

*DUPLICATE*

File: Wednesday, 4/26/2006 1:17:55 PM  
User: Linda Lacelle

# Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: FWD X-TUBE EXT HEIGHT(-013)
Job Number	: 24946	Part Number	: D205596105
Estimate Number	: 10565	Drawing Number	: D205596105
P.O. Number	: <i>N/A</i>	Project Number	: N/A
This Issue	: 4/26/2006 S.O. No. : <i>N/A</i>	Drawing Revision	: A
Prsht Rev.	: NC	Material	: <i>N/A</i>
First Issue	: 11/23/2005 Type : LANDING GEAR	Due Date	: 1/15/2006
Previous Run	: 24078	Qty:	1 Um: Each
Written By	: <i>[Signature]</i>		
Checked & Approved By	: _____		
Comment	: Est Rev:D 05.03.21 Added bending procedure KJ/JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	DC	DOCUMENT CONTROL
<b>Comment:</b> DOCUMENT CONTROL Photocopy D205-594 bluefile & type labels per PPP D205-596-105 CHG001		
2.0	D2889	FWD Crosstube
<b>Comment:</b> Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Pick: Qty Part number Description Batch 1 D2889 Aft Crosstube <i>B22533 DP06-4-260</i>		
3.0	BENDING	BENDING MACHINE
<b>Comment:</b> BENDING MACHINE Bend D2890 as per Dwg D2889 and Folio FT001 <i>DP06-4-260</i>		
4.0	QC6	DIMENSIONAL CHECK
<b>Comment:</b> DIMENSIONAL CHECK		
5.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
<b>Comment:</b> LANDING GEAR RESOURCE.1 <i>fmr 06-05-8-1</i> Deburr and Polish		

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Wednesday, 4/26/2006 1:17:55 PM  
User: Linda Lacelle

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Drawing Name: FWD X-TUBE EXT HEIGHT(-013)

Job Number: 24946

Part Number: D205596105

Job Number:



Seq. #:	Machine Or Operation:	Description :
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6.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1  
Chemical Conversion Coat as per QSI 005 4.1

7.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
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Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

06-05-31 (1)

8.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
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Comment: LANDING GEAR RESOURCE 1  
Mark 23.92" for cutting from tangential line in the straight section from D2889 as per Dwg wall template.

D205-425

9.0	QC6	DIMENSIONAL CHECK
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Comment: DIMENSIONAL CHECK  
Inspect dimensions. Conformity check and sign off by engineering.

Bacos 05

10.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
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Comment: LANDING GEAR RESOURCE 1

1-Cut as per Dwg D205-596-105

D205-6-8

2-Deburr & Inspect for surface damage. Polish cut surface. Scribe part # and batch # on one end of tube.

Pin 06-05-008

11.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

Pin 06-05-240 (1)

Touch up ends of the tube with Chemical Conversion Coat per QSI 005 4.1

12.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

06-05-31 (1)

13.0	SPRAY PAINTING	SPRAY PAINTING
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Comment: SPRAY PAINTING

1-Prime inside and outside with Immron per QSI 005 4.2

M 06 07 27 (1)  
M 06 07 28 (1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 4/26/2006 1:17:55 PM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FWD X-TUBE EXT HEIGHT(-013)

Job Number: 24946

Part Number: D205596105

Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

QC14

Inspect Spray Paint



Comment: Inspect Spray Paint

*2007-31 (1)*

15.0

D2856600

Abrasion Strip



Comment: Qty.: 1.4895 f(s)/Unit Total : 1.4895 f(s)

Pick:

Qty Part number

Description

Batch

2 D2856-600(8.51") Abrasion Strip

*624328*

*2T*

*06-08-28*

16.0

D28931

Support



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number

Description

Batch

2 D2893-1

Support

*624475*

*2T*

*06-08-28*

17.0

MS2192024

Clamp(per MIL-DTL-8783C)



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part number

Description

Batch

4 MS21920-24

Clamp

*M19349*

*2T*

*06-08-28*

18.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Install abrasion strips per QSI 035 position using DT8582. Install supports and clamps per Dwg D205-596-105. Torque clamps to 80-100 in lb. Seal edges of support using Sikaflex

*IT 06-08-28*

A/R Sikaflex -291

*N/A*

*optional*

Expiry date:

*N/A*

19.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*DP 6-8-29*

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
06/08/30	18	SEAL EDGES of Support using Sikaflex if <del>require</del> Remove			NA		06/08/30

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ \_\_\_\_\_ Date: 06/08/30  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Wednesday, 4/26/2006 1:17:55 PM  
User: Linda Lacelle

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FWD X-TUBE EXT.HEIGHT(-013)

Job Number: 24946

Part Number: D205596105

Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D205-596-105

Location: \_\_\_\_\_

PPP Rev: C

*26/4/29* (1)

21.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

*06/08/30* (1)

Job Completion



*C Loc 108/30*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

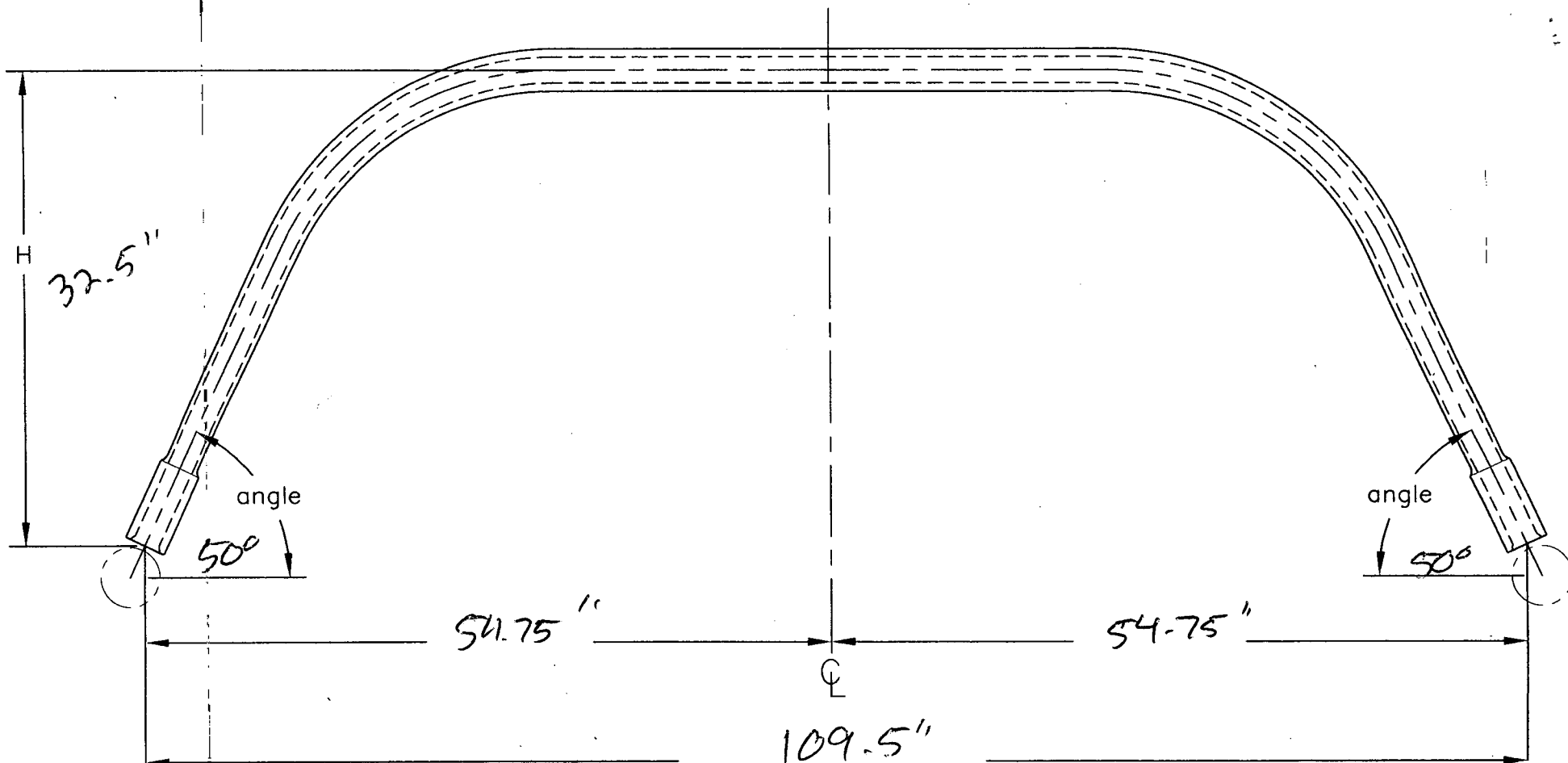
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries





DATE: 06-05-05  
 DESCRIPTION: D205-596-105  
 BATCH NO: 24946  
 DRAWING: D205-596-105 Rev A  
 H: 32.5"  
 1/2 SPAN: 54.7"  
 TOTAL SPAN: 109.4"  
 ANGLE: 51°

*Handwritten signature/initials*  
06-05-05

Thursday, 11/16/2006 4:25:23 PM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: FWD X-TUBE
Job Number	: 29485		
Estimate Number	: 10006		
P.O. Number	: <i>N/A</i>	Part Number	: D2889
This Issue	: 11/16/2006 S.O. No. : <i>N/A</i>	Drawing Number	: D2889 REV B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: <i>MA</i> Type : LANDING GEAR	Drawing Revision	: B
Previous Run	: 29484	Material	: <i>N/A</i>
Written By	:	Due Date	: 12/10/2006 Qty: 1 Um: Each
Checked & Approved By	: <i>06 11 17</i>		
Comment	: Est Rev:A New Issue 05-10-25 JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6005180	Crosstube material
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)  
 Crosstube material  
 Pick:

Qty	Part number	Description	Batch
1	D2889	Fwd Crosstube	<i>25673</i>

2.0	BENDING	BENDING MACHINE
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Comment: LANDING GEAR RESOURCE 1  
 1-Bend D2889 as per Dwg D2889 and Folio FT001

*EL. 7-3-20*

3.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
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Comment: LANDING GEAR RESOURCE 1

1-Deburr and Polish

*N/A*

4.0	QC6	DIMENSIONAL CHECK
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Comment: DIMENSIONAL CHECK

*20703-28*

5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1  
 Acid etch and alodine as per QSI 005 4.1  
 Inside and outside of tube

*N/A*

*See Attached dim sheets*